

Date: Monday, 02/02/2009 11:49:47 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK SADDLE
Job Number	: 45383		
Estimate Number	: 11177		
P.O. Number	:	Part Number	: D2281
This Issue	: 02/02/2009 S.O. No. :	Drawing Number	: D2281 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: G
Previous Run	: 44442	Material	:
Written By	:	Due Date	: 03/03/2009 Qty: 100 Um: Each
Checked & Approved By	: <u>Julie Dawson</u>		
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM Est: rev B 06.07.17 waterjetEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS sheet .080
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cut of MAT



Comment: Qty.: 0.1313 sf(s)/Unit Total: 13.1250 sf(s)
 304SS .080 109358 IB 9-2-22
 batch: _____

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2281
 Dwg Rev: G
 Prog Rev: G

IB 9-2-22



2-Deburr if necessary IB 9-2-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/02/23 counter
 (X82)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Deburr

1/45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 11:49:47 AM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 45383

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 09/03/10

92

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: MISC

SP 09.03-10

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



MF 09-03-10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: NS383
Description: Jack Saddle		Part Number: D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.473				
4.114	+/-0.010	4.114				
2.933	+/-0.010	2.937				
1.535	+/-0.010	1.540				
0.354	+/-0.010	.354				
0.354	+/-0.010	.354				
0.604	+/-0.010	.603				
2.000	+/-0.010	2.001				
3.396	+/-0.010	3.395				
3.646	+/-0.010	3.646				
4.000	+/-0.010	4.001				
1.525	+/-0.010	1.536				
2.475	+/-0.010	2.476				
Ø0.323	+0.006/-0.001	.325				
0.080	+/-0.010	.074				

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-2-22	Date: 09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

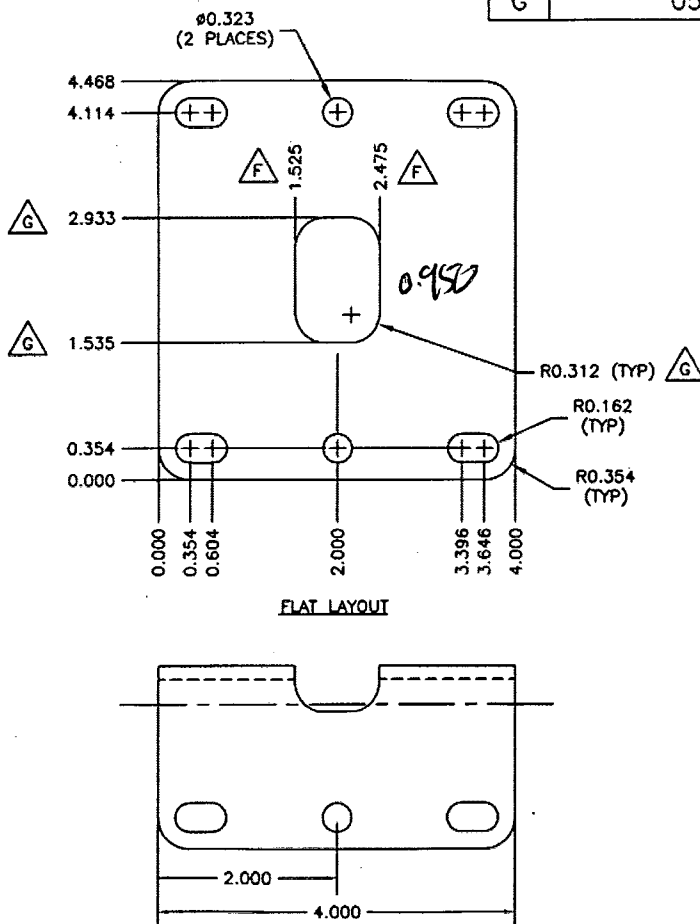
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NOTE: Date & initial all entries

DARTRELEASED
05/08/11

DESIGN BW	DRAWN BY 73	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED MKS	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

812
2.833
1.535
1.398**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15383

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